

Work Order ID 73001

Tuesday, August 23, 2011 10:19:03 AM



Page 1

Item ID:	D3012-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Decal					
Start Date:	8/23/2011	Start Qty:	12.00			
Required Date:	9/6/2011	Req'd Qty:	12.00			
Reference:						

Approvals:	Process Plan:	<i>MFC</i>	Date:	<i>11-08-23</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3012	Rev A								

100		0.00							
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	PURCHASING								
Purchasing									
Purchasing	Memo	0.00							
	Issue P/O: <i>14719</i>								
	Make per Dwg D3012								
	Manufacture from 3M 7mil masking film p/n 8522CP								
	Material release note required								

11-08-23
(12)

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
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Packaging									
Packaging	Memo	0.00							
	Ensure Material Release Note is attached								

Pull 8/29 *(12)*

120	QC6- Inspect dimensions to drawing	0.00							
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QC									
Quality Control	Memo	0.00							

8 w/ 8/29

(412)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73001

Tuesday, August 23, 2011 10:19:03 AM



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Item ID: D3012-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Decal

Start Date: 8/23/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/6/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location ST 30

0.00

[Handwritten signature]



Packaging

Memo

0.00

Packaging

(12x) Sep 1-08-29

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/29

11/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 23, 2011 10:19:01 AM

Page 1

Work Order ID: 73001



Parent Item: D3012-3



Parent Item Name: Decal


Start Date: 8/23/2011

Required Date: 9/6/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 01.04.06 New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3012-3P  Decal		Purchased	No			110	Each	0.0000	1	12		8/29/11	(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3012	REV. A SHEET 1 OF 1
DATE 01.03.30		TITLE DECAL	SCALE 1:1
A	01.03.30	NEW ISSUE	

RELEASED
01.04.30 *[Signature]*

- POINT A -
SWL=300lb/136kg
DO NOT USE WITH POINT B
P/N D3012-1

D3012-1

- POINT B -
SWL=500lb/227kg
DO NOT USE WITH POINT A OR C
P/N D3012-3

D3012-3

- POINT C -
SWL=300lb/136kg
DO NOT USE WITH POINT B
P/N D3012-5

D3012-5

MATERIAL: WHITE LETTERS ON BLACK ADHESIVE BACK
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP

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Product & Instruction Bulletin 8522

Release I, Effective September 2008

See Bulletin Change Summary and end of Bulletin

This Bulletin now includes Instruction Bulletin 4.23

Scotchcal™ Changeable Opaque Imaging Media 8522

Product Description

Recommended Types of Graphics and End Uses

For Thermal Inkjet Printing

This durable, 7 mil, opaque, changeable film is optimized for use with selected thermal inkjet printers and inks. Ink dries quickly on the film. When overlaminated, it is warranted for medium term, outdoor weatherable graphics, and long term indoor graphics.

When constructed and used as described in this Bulletin, these types of graphics and end uses may be warranted by the 3M™ MCS™ Warranty. Please read the entire Bulletin for details.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics
 - Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

3M specifically does not recommend or warrant the following uses, but please contact us to discuss your needs or recommend other products.

Unsuitable End Uses for This Product

- Not for electronically cut individual letters and numbers
- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wallboard
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.
- Graphics made for automotive Original Equipment Manufacturers (OEM); contact 3M Automotive Division at 1-800-328-1684 for alternatives.

About Water-Based Inkjet Technology

Standard inkjet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this Bulletin. Staying in the middle of these ranges always provides optimum performance.

Characteristic	Description
Warranted application substrates	<p>Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.</p> <ul style="list-style-type: none"> • Alodine (anodized aluminum) • Automotive panels (automotive painted steel) • Fruehauf (painted aluminum) • FRP (fiberglass reinforced plywood) • Glass • Imron® (polyurethane-painted metal panel) • Acrylic • Sintra™ board <p>Note: Use on any other substrate is strictly on a graphics manufacturer and customer test and approve basis. Test for both adhesion and removal characteristics. The plasticizer in some banner materials may migrate. This may cause the edge of the graphic to peel or lift off of the banner. For optimum performance, follow the guidelines in the section, Creating A Laminated Overlap, on page 4.</p>

Warranty Information

The warranty given in the Product Bulletin that is current at the time you purchased the film is the one that 3M will honor. **The warranties in the following table(s), given in years, are for finished graphics exposed in a vertical exposure in the United States except the Desert Southwest.** See the warranty sections following this table for additional information.

3M™ MCST™ Warranty Durability for Finished Graphics

Construction (film and overlamine on warranted substrate)	HP Printers & Inks		Epson Printers & Inks		Removal
	Outdoor	Indoor	Outdoor	Indoor	
8522/8519	3 years	5 years	2 years	5 years	1 year without chemical strippers or tools
8522/8520					

Warranty and Limited Remedy

The following is made in lieu of all other express or implied warranties, including any implied warranty of **merchantability** or fitness for a particular purpose or implied warranty arising out of a course of dealing, custom or usage of trade: all 3M products are warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in this Product Bulletin. 3M will replace or refund the price of any 3M materials that do not meet this warranty within the specified time periods. These remedies are exclusive. **In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor or non-3M materials charges.**

See the Graphics Market Center Warranty Brochure, which gives the terms, additional limitations of the warranty, if any, and limitations of liability.

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 16270
Date: 08/26/2011
Ship Date:
Page: 1
Re: Order No. 11360

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		12	D3012-3P set up	H	4.1667	50.00
		12	D3012-1P set up	H	4.1667	50.00
		12	D3012-5P set up	H	4.1667	50.00
		1	printing	H	75.0000	75.00
			H - HST 13%			
			HST			29.25
			PST Exempt: #6122-5207			
Total Amount						254.25

Studio de Lettrage HST: #869034678RP001

Prepared By: Tracking Number:

Payment: PO 14719

By:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14719

Purchase Order Date 8/23/2011

PO Print Date 8/23/2011

Page Number 1 of 1

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
110 MAIN WEST
HAWKESBURY, ON K6A 2H6
CANADA

Contact Name

Order Phone 613 632 5449

Order Fax 613 632 9491

Order Account Nbr

Buyer Brigitte Golden

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Order Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D3012-3P	Decal	8/26/2011 Yes	12.00 Each	Yours ppd	\$6.6600 6.25	\$79.92
D3012-1P	Decal	8/26/2011 Yes	12.00 Each	Yours ppd	\$6.6800 6.25	\$80.16
D3012-5P	Decal	8/26/2011 Yes	12.00 Each	Yours ppd	\$6.6600 6.25	\$79.92
PO Total:						\$240.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Order Number:

Change Date: 8/23/2011